

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Work Order ID 133024

Wednesday, May 27, 2015 3:15:44 PM

133024

Page 2

Item ID: PB67-43001-19 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Inner Tube And Retainer Bushing
Start Date: 5/22/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/5/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130	HandFinish	0.00							DAS 9 9-89
	Hand Finishing								
140	QC7-Inspect Chemical Conversion Coat	0.00							
140	QC	0.00							DAS 9 9-89
	Quality Control								
150	Identify as per dwg & Stock Location: WA3	0.00							
150	Packaging	0.00							DAS 24 9-89
	Packaging								

N/A

JUN 24 2015

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OTHER : ☐					

Work Order ID 133024

Wednesday, May 27, 2015 3:15:44 PM

133024

Page 3

Item ID: PB67-43001-19

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Inner Tube And Retainer Bushing

Start Date: 5/22/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/5/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

ML5

JUN 25 2015

MF
15-6-24

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OTHER : ☐									

Picklist Print

Wednesday, May 27, 2015 3:15:43 PM

Page 1

Work Order ID: 133024

133024

Parent Item: PB67-43001-19

PR67-43001-19

Parent Item Name: Inner Tube And Retainer Bushing

Start Date: 5/22/2015

Required Date: 6/5/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
10.09.28 per rev C dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

PB67-43001-287

Manufactured No

100

Each

1.0000

1

1

PR67-43001-287

Inner Tube Guide, Blade Positioner

Location

Loc Qty

Loc Code

Mezz2

1

104823

1

ME 15-6-11

PB67-43001-295

Manufactured No

100

Each

1.0000

1

1

PR67-43001-295

Extension Tube, Blade Positioner

Location

Loc Qty

Loc Code

Mezz2

1

113426

1

ME 15-6-11

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Misidentified ☐	Past Due ☐																																																																

ITEM	QTY -19	P/N	DESCRIPTION
1	X	B67-43001-19	INNER TUBE AND RETAINER BUSHING
3	1	B67-43001-295	EXTENSION TUBE, BLADE POSITIONER
4	1	B67-43001-287	INNER TUBE GUIDE, BLADE POSITIONER

B67-43001-295
EXTENSION TUBE, BLADE POSITIONER

B67-43001-287
INNER TUBE GUIDE, BLADE POSITIONER

0.50

B67-43001-19 INNER TUBE AND RETAINER BUSHING

cmf
#1330241

RELEASED
2009-09-24
mb

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.21 lbs
 8) WELDING: PER QSI 004

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 13 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.25
REV	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>AS</i>	DRAWING NO. B67-43001-19 REV. C		
CHECKED	<i>MB</i>	SHEET 1 OF 1		
MFG. APPR.	<i>MB</i>	TITLE		
APPROVED	<i>MB</i>	INNER TUBE AND RETAINER BUSHING NTS		
DE APPR.	N/A	SCALE		
DATE	09.06.25	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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